

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave.St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013767**Date Inspected:** 13-Apr-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gang Wai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Out Side

This QA Inspector observed the following work in progress:

SMAW in the 4F position for the OBG Segment 10CE, weld No.SSD17-PP93-177/178. The welder is identified as #069683. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

SMAW in the 4F position for the OBG Segment 10CE, weld No.SSD17-PP93-201/202. The welder is identified as #067656. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

SMAW in the 3G position for the OBG Segment 10CE, weld No.SSD17-PP93-179 The welder is identified as #050969. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2213-Tc-U4b-FCM-1.

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This QA Inspector observed the following work in progress:

FCAW in the 2G position for the OBG Segment 12CE, weld No.SEG3003S-126. The welder is identified as #050242. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

FCAW in the 2G position for the OBG Segment 12CE, weld No.SEG3003S-056. The welder is identified as #044774. ZPMC QC is identified as Mr. Guo Xing Hui. The welding variables recorded by QC appear to comply with WPS-B-T-2232-Tc-U4b-F.

SMAW in the 2G position for the OBG Segment 10BW, weld No.CA073-004. The welder is identified as #051348. ZPMC QC is identified as Mr. Xu Tao. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-FCM-REPAIR-1. The weld repair report is identified as B-CWR-1342.

Magnetic Particle Testing (MPT)

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for Tower 18 meter Strut Ring Pad eye welds area. This QA inspector generated a (MT) report for this date. This weld was previously tested and accepted by ZPMC QC MT technicians.

The weld designations reviewed are as follows:

SL3-010,024,028

Green Tagging

This QA inspector performed Visual Inspection for Green Tagging which were previously tested and accepted by ZPMC Quality Control personnel and ABF QA personnel. The members are identified as Tower 18M Strut Ring.

The Strut Rings are as follows:

Skin A18M EN Green Tag No: 11730

Skin A18M WS Green Tag No: 11731

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By: Bera,Subhasis

Quality Assurance Inspector

Reviewed By: Patterson,Rodney

QA Reviewer